

Date: Monday, 07/04/2008 2:30:10 PM
 User: Julie Lecocq

Process Sheet

| | | | |
|----------------------------------|--|-------------------------|-----------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : FUEL PURGE CANISTER |
| Job Number | : 38446 | | |
| Estimate Number | : 10440 | | |
| P.O. Number | : | Part Number | : D3262041 |
| This Issue | : 07/04/2008 | S.O. No. | : |
| Prsht Rev. | : NC | Drawing Number | : D3262 REV C |
| First Issue | : / / | Project Number | : N/A |
| Previous Run | : 37369 | Drawing Revision | : C |
| | Type : MACHINED PARTS | Material | : |
| Written By | : | Due Date | : 30/04/2008 |
| Checked & Approved By | : <u>JD 08-4-06</u> | Qty: | 4 Um: Each |
| Comment | : Est. C 05.03.10 Removed P/O for liquid penetrant inspection K J/JLM | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|--------|---------------------|
| 1.0 | 38446A | FUEL PURGE CANISTER |
|-----|--------|---------------------|



Comment: Sub-Component FUEL PURGE CANISTER
 D3262-1 B 100804 4P 36777A ZE 08/05/21

| | | |
|-----|--------|---------------------|
| 2.0 | 38446B | FUEL PURGE CANISTER |
|-----|--------|---------------------|



Comment: Sub-Component FUEL PURGE CANISTER
 D3262-3 B 34242 8P ZE 08/05/21

| | | |
|-----|-------------|------------------------------|
| 3.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1
 Weld canister assembly as per Dwg D3262 using DT8739 to align fillings
 Pick: Qty Part Number Description Batch
 A/R Aluminum Rod M107877 ZE 08/05/21

| | | |
|-----|-----------|---------------------------|
| 4.0 | QC9 / QCS | VISUAL WELDING INSPECTION |
|-----|-----------|---------------------------|



Comment: WELD INSPECTION
 Pressure test as per Dwg D3262

QC9 AD 08-05-22 (4)
QCS-5 08/05/22 (4)

| | | |
|-----|-----------------|----------------------------|
| 5.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|



Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

M-L 08/05/22

(4X)

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL PURGE CANISTER

Job Number: 38446

Part Number: D3262041

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|----------------|----------------|
| 6.0 | POWDER COATING | POWDER COATING |
|-----|----------------|----------------|



M107925



Comment: POWDER COATING

1-Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3
2-Ensure to mask threads

MF 08/05

30 min
22/05/2008

S.268

#1 319.7

#2 B38446

#3

#4 D3262041

| | | |
|-----|-----|---|
| 7.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |
|-----|-----|---|



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 08-05-22

| | | |
|-----|-------------|-----------------------|
| 8.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N as per Dwg using a permanent fine point marker, then Stock
Location: _____

8/5/23

SP

(4A)

| | | |
|-----|------|------------------------------|
| 9.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
|-----|------|------------------------------|



Comment: FINAL INSPECTION/W/O RELEASE

08/05/26

Job Completion

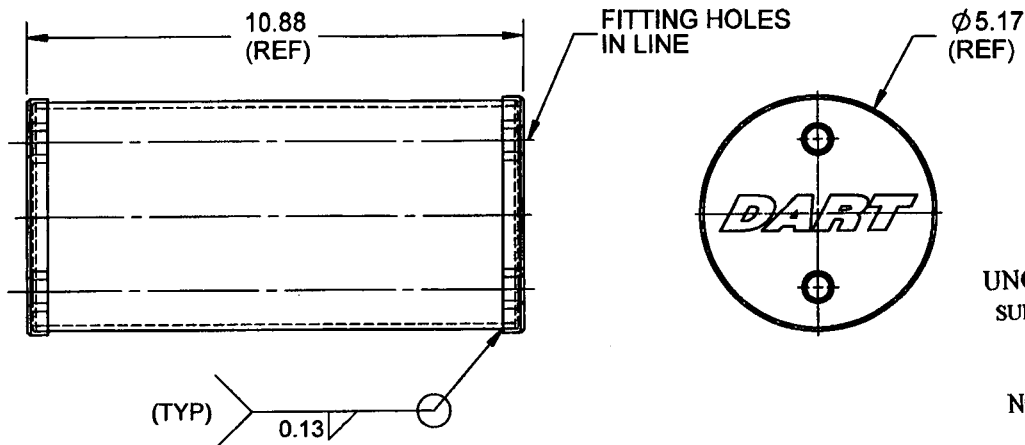


MF 08-05-23

DART

| | | | |
|------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>PH</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3262 | REV. C SHEET 1 OF 2 |
| DATE 06.08.31 | | TITLE FUEL PURGE CANISTER SCALE 1:4 | |
| REV | DATE | DESCRIPTION | |
| A | 04.05.06 | FIRST ISSUE | |
| B | 05.02.14 | ADD PRESSURE TESTING OPTION | |
| C | 06.08.31 | Ø5.165 WAS Ø5.190 | |

RELEASED

06.09.19 *[Signature]*

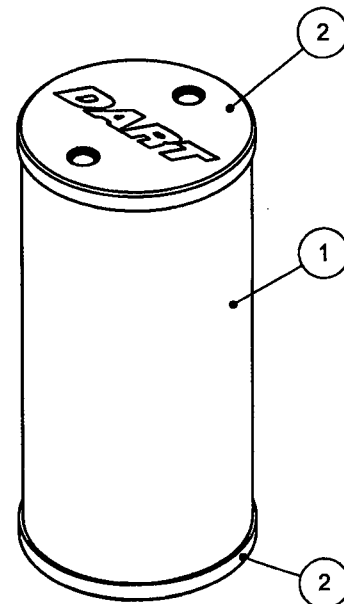
SHOP COPY
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WORK ORDER
NO. *3844*

D3262-041 CANISTER ASSEMBLY

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|-----------|-------------------|
| | X | D3362-041 | CANISTER ASSEMBLY |
| 1 | 1 | D3262-1 | TUBE |
| 2 | 2 | D3262-3 | CAP |

NOTES:

- 1) WELD PER DART QSI 004
- 2) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS *[Symbol]*
- 4) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) IDENTIFY WITH DART P/N AND B/N USING FINE POINT PERMANENT INK MARKER



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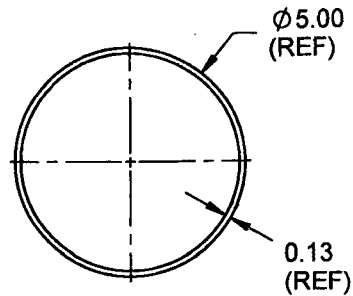
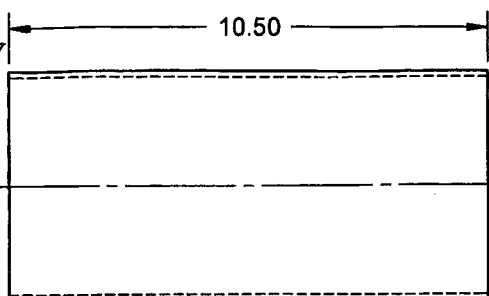
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| | | |
|-------------------------|-------------------------------------|--|
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| CHECKED <i>PH</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3262 |
| DATE 06.08.31 | TITLE FUEL PURGE CANISTER | REV. C SHEET 2 OF 2 SCALE 1:4 |

SHOP COPY

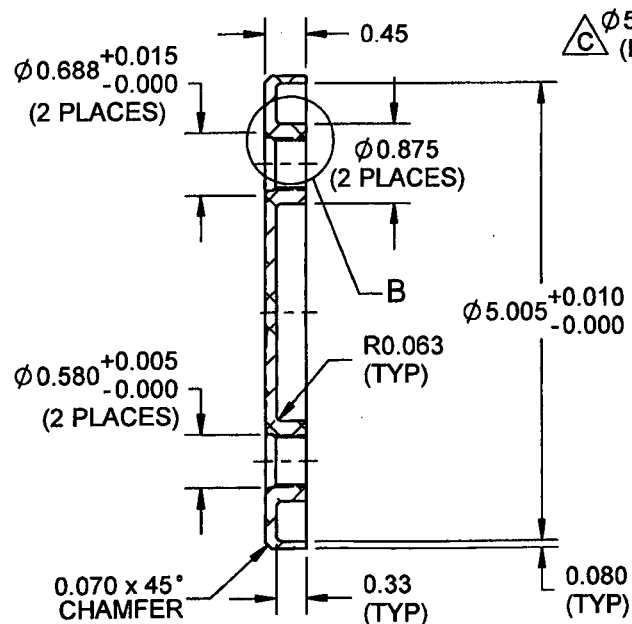
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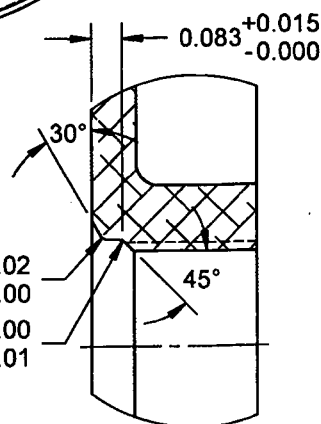
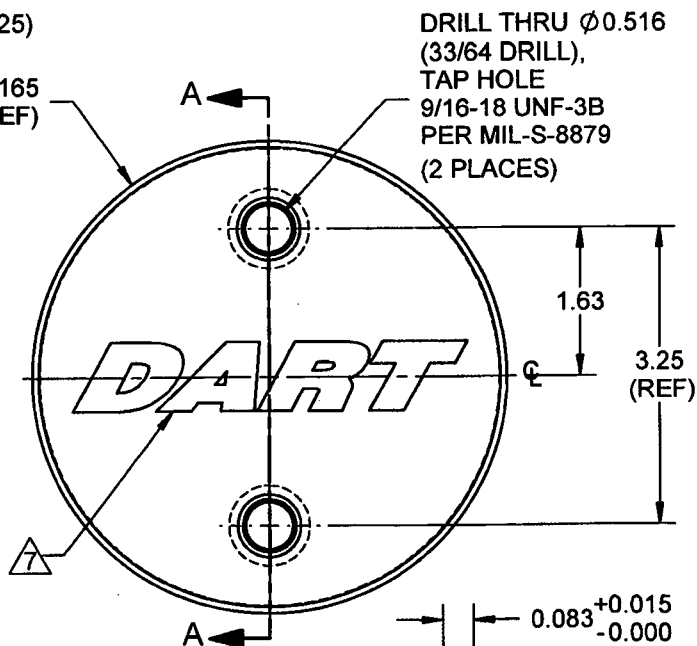
RELEASED
06.09.11

D3262-1 TUBE

1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, 5.00 OD x 0.125 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR
QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T5.000W.125)



SECTION A-A
SCALE 1:2



DETAIL B
SCALE 2:1

D3262-3 CAP

1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR
(REF. DART SPEC. M6061T6B)

NOTES:

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.005 TO 0.010
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE
- 7) ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH TOOL RADIUS OF 0.25 (MIN)

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